

Work Order ID 81861

81861

Page 1

Tuesday, March 20, 2012 9:27:12 AM

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: *[Signature]*

Date: *12-03-20*

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

0.00

0.00

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002
NON EUROCOPTER

Sizkuli

Ag for MLT 12-4-17
(4)

110

110

Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
D3272

A/RAluminum Rod *119185*
120169

3-Grind End Plate flush

12-04-03

→ Ac 12.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

81861

Tuesday, March 20, 2012 9:27:12 AM

N900040100

Stop ***NS2***

4

4

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

120

QC

Memo

0.00

0.00

130

QC

Memo

0.00

0.00

140

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Start Date: 3/20/2012 Start Qty: 4.00

4

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Required Date: 3/27/2012 Req'd Qty: 4.00

4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150						x 4			ll.
QC	Memo	0.00							12.04.12
Quality Control									
180		0.00							
180	Large Fab					4	Ø		Ac
Large Fab	Memo	0.00							12.04.12
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								ll
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAIuminum Rod <u>119785</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		5176113					
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5176113		xy xy			
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4X			m 12/04/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Tuesday, March 20, 2012 9:27:12 AM

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step, Long LH
Start Date: 3/20/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/27/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220 Powdercoat Powder Coating <i>M120222</i>	Memo START TIME: <i>2:45</i> OVEN TEMPERATURE: <i>320 OF</i> FINISH TIME: <i>3:15</i>	0.00				<i>4X</i>	<i>0</i>		<i>MJK 12/04/13</i>
230	Wing Walk as per dwg QSI005 4.4 Batch <i>120902</i>	0.00							
230 HandFinish Hand Finishing	Memo	0.00				<i>4X</i>	<i>0</i>	<i>DP</i>	<i>12/04/17</i>
240	QC3- Inspect Part Finish	0.00							
240 QC Quality Control	Memo	0.00				<i>4X</i>	<i>0</i>		<i>8/26/19</i>

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Run Start *NR1*

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Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-3 i

Location: FG072

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID 81861***81861***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/4/19

MR

12-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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81861

D350-591-311

Required Date: 3/27/2012

Required Qty: 4.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011		Manufactured	No				Each	0.0000		4			
DSI 9410-011													
Step Modification									**			83463	
D3272-1		Manufactured	No			110	Each	20.0000	1	4			
D3272-1													
Step									**			12.03.28	
				<u>Location</u>			<u>Loc Qty</u>						
				ST			B82019	-10				4	
				WA				30					
					80179			10					
					80180			10					
D3067-1		Manufactured	No			110	Each	158.0000	1	4			
D3067-1													
End Plate									**			12.04.03	
				<u>Location</u>			<u>Loc Qty</u>						
				WA				132				4	
					78608			72					
					80881			60					
				WA016				26					
					67582			2					
					68214			1					
					79607			23					

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Picklist Print

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Tuesday, March 20, 2012 9:27:30 AM

Work Order ID: 81861

81861

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3219-1 Manufactured No

110 Each

60.0000 2 8

D3219-1

Plate

**

12.04.03

Location

Loc Qty

Loc Code

WA016 B82059 60
73410 12
77674 6
78763 42

6

2

D3066-1 Manufactured No

180 Each

46.0000 2 8

D3066-1

Spacer

**

B81968 (X8) Ac 12.04.11

Location

Loc Qty

Loc Code

WA 46
78605 46

MS20600-AD4W4 Purchased No

180 Each

2,518.000 16

MS20600-AD4W4

Rivets

**

64 121340
11121390 Ac 12.04.11
(64)

Location

Loc Qty

Loc Code

ST321 2513
116188 59
117364 253
117601 200
117885 195
118840 1089
119860 30
119883 155
120308 72
120769 260
121011 200
WA018 5
116712 5

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 81861

81861

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3065-041

Manufactured No

180

Each

34.0000

1

4

D3065-041

Step Leg Assembly Hi

**

B 78798 (x4) Ac 12-04-11

Location

Loc Qty

Loc Code

WA

34

66149

0

78799

33

79336

1

D3067-1

Manufactured No

180

Each

158.0000

1

4

D3067-1

End Plate

**

12-04-12

Location

Loc Qty

Loc Code

WA

132

78608

72

80881

60

WA016

26

67582

2

68214

1

79607

23

AN3-35A

Purchased

No

250

Each

247.0000

2

8

AN3-35A

Bolt

**

12/04/18

Location

Loc Qty

Loc Code

ST353

247

120187

47

120644

50

120717

50

121068

100

4x120187

4x121068

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Page 4

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D3235-1 Manufactured No 250 Each 145.0000 2 8 ✓

D3235-1

Mounting Lug

** 1

Location

Loc Qty

Loc Code

ST

145

78787

145

78787

D3278-041 Manufactured No 250 Each 1.0000 1 4 ✓

D3278-041

Support Assembly

** 3X 78795 JB

Location

Loc Qty

Loc Code

ST481

1

78794

1

1X 78794

AN960JD416 NAS1149D0463J Purchased No 250 Each 14.0000 16 64 ✓

AN960.ID416

Washer

** 121255 JB

Location

Loc Qty

Loc Code

ST351

14

116289

14

AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000 4 16 ✓

AN960.ID516

Washer

** JB

AN5-36A Purchased No 250 Each 162.0000 2 8 ✓

AN5-36A

Bolt

** 118614 JB 12/04/18

Location

Loc Qty

Loc Code

ST340

162

120187

112

120731

50

120187

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

D2618

Manufactured No

250

Each

304.0000

2

8

D2618

Bushing

**

JB

Location

Loc Qty

Loc Code

ST012

304

76130

2

78537

102

80474

200

78537

D2230-3

Manufactured No

250

Each

179.0000

4

16

D2230-3

Lug

**

16
\$81550

Location

Loc Qty

Loc Code

ST480

179

53881

4

70973

1

80009

174

D2856-400

Manufactured No

250

f

197.2345

1.2

4.8

D2856-400

Abrasion Strip

**

JB 12/04/18

Location

Loc Qty

Loc Code

ST409

197.2345

63735

0.6696

68076

0.3149

71164

8.46

79551

187.79

79551

*** cut (2) at 7.20" (D2856-400-720) ***

→ measure 8/24/19

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

250

Each

3,027.000

2

8

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

3027

117441

16

117885

32

118451

5

118927

3

119017

2798

119075

173

119017

AN4-13A

Purchased

No

250

Each

1,357.000

8

32

**

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

1357

119449

59

120187

398

120422

500

120770

400

120422

MS21042L5

Purchased

No

250

Each

1,588.000

2

8

**

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1588

116105

5

116548

43

117611

42

119109

1498

119109

Dart Aerospace Ltd

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/20/2012

Required Date: 3/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4 Purchased No

250 Each

5,307.000

8

32

MS21042L4

Nut

**

1

JB

12/04/18

Location

Loc Qty

Loc Code

ST300

5307

117441

51

117601

21

118451

133

119017

200

119075

2902

121011

2000

119075

AN960JD10 NAS1149D0363J Purchased

No

250

Each

0.0000

4

16

AN960.ID10

Washer

**

121243

JB

12/04/18

Dart Aerospace Ltd

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. 'B' SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *81861*

12-03-20

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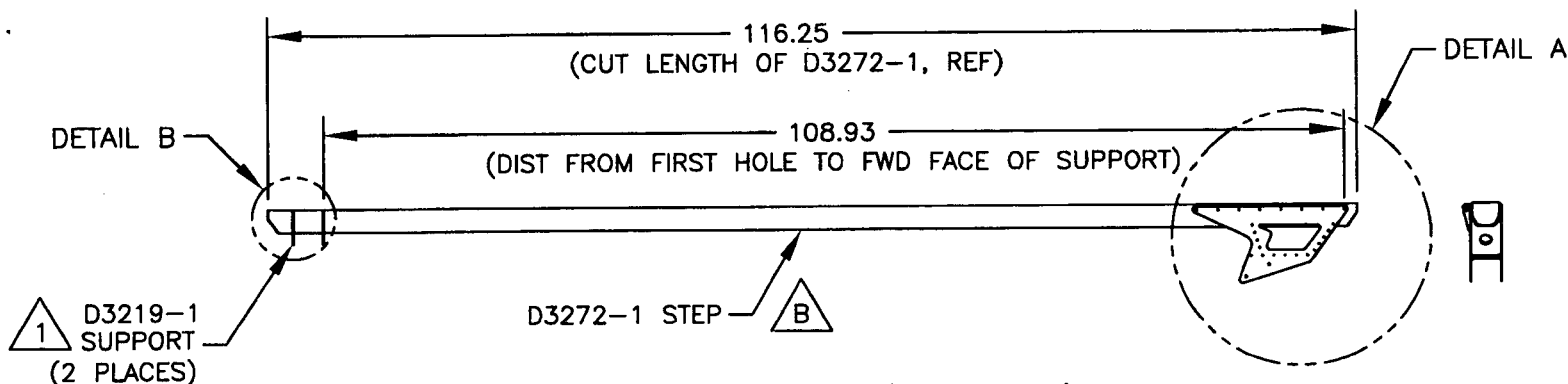
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

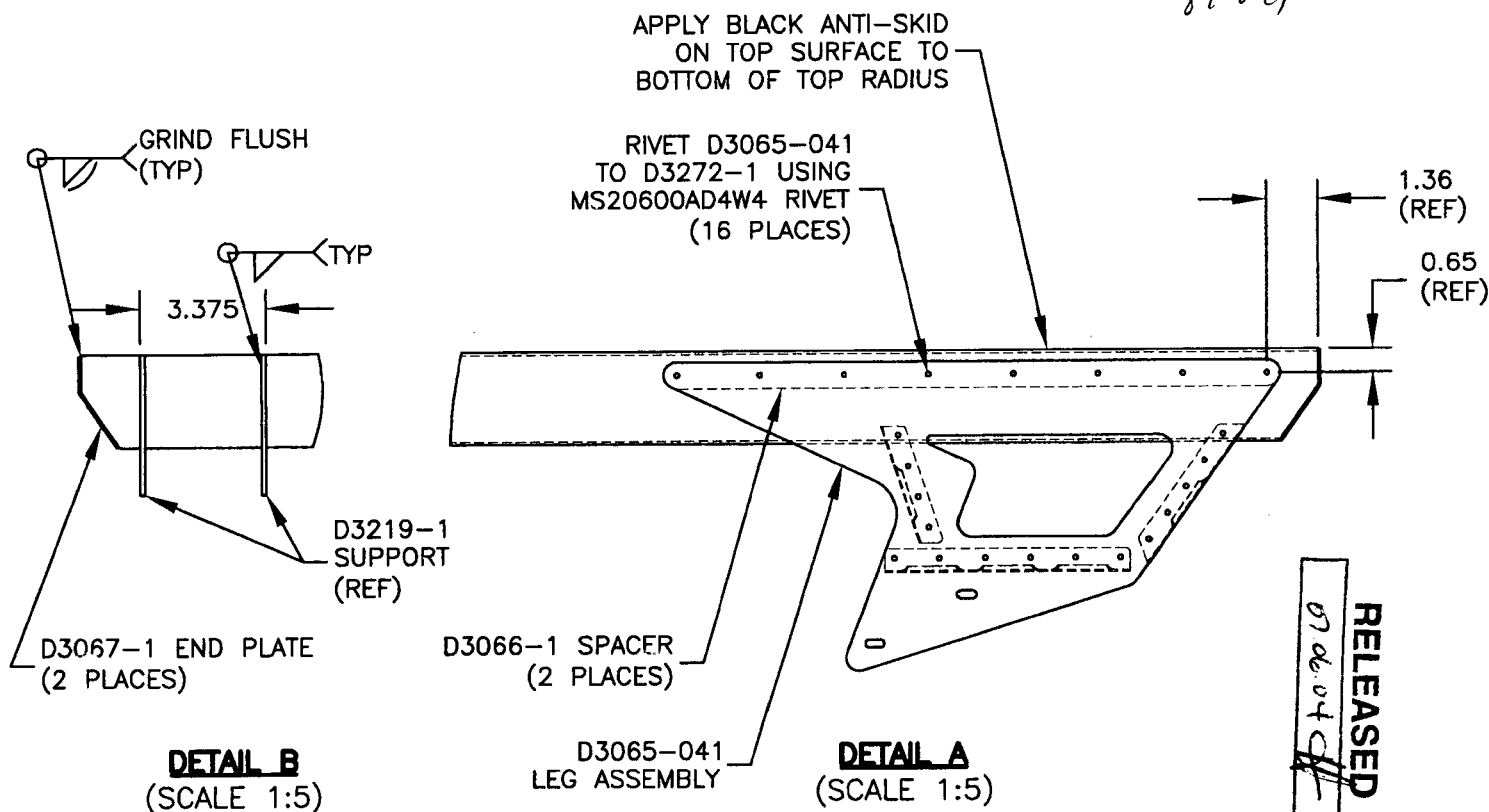
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	q	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

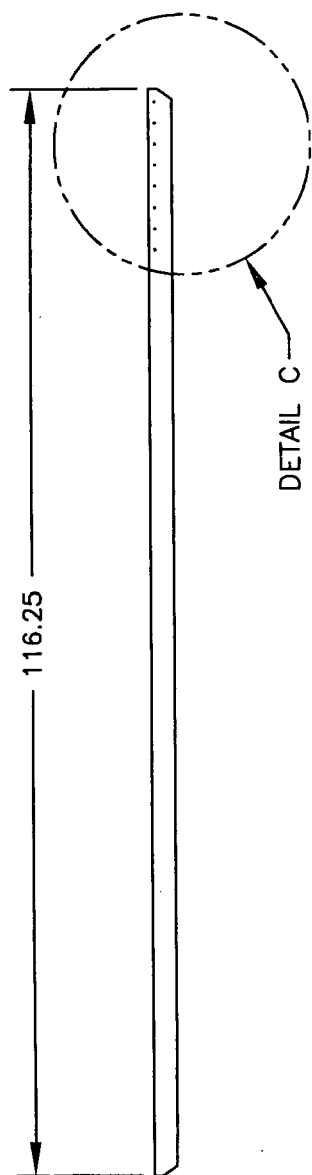
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

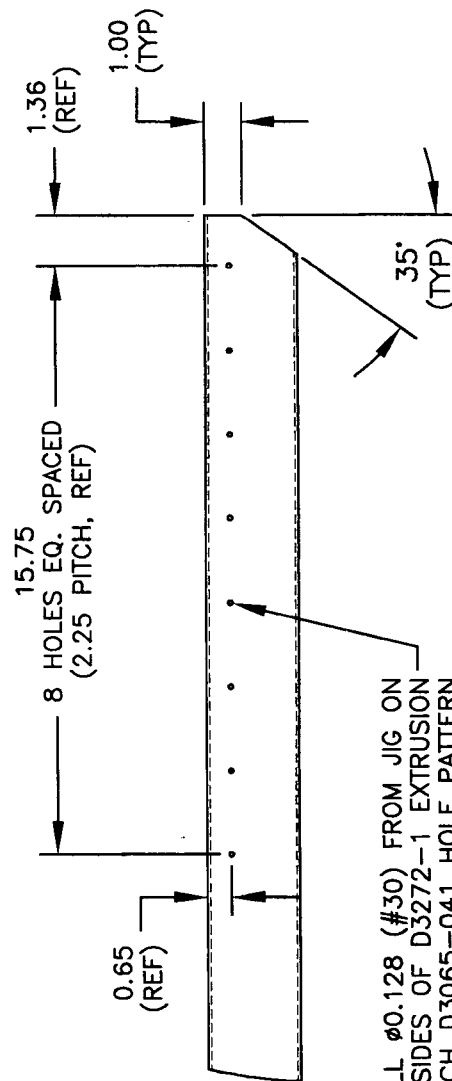
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

81861



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.